

Work Order ID 146401-1

Wednesday, August 03, 2016 1:32:03 PM

Split - *146401*

Page 1

Item ID: D3916-041 Accept *N9000040100* Setup Start *NS1*

Revision ID:

Item Name: Rib Assembly Stop / *NS2*

Start Date: 6/16/2016 Start Qty: 10.00 *10* 654

Required Date: 6/21/2016 Req'd Qty: 10.00 *10* 654

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: QAS 21 Date: AUG 03 2016 Tooling: Date:

QC: 9-89 Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3916	A

100 0.00

100

Large Fab

Large Fab

Memo

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

0.83

0 5 160803

105 QC6- Inspect dimensions to drawing 0.00

105

QC

Quality Control

Memo

0.00

10x

DAS 43 9-89

AUG 08 2016

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Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 6/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/21/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107	Weld per dwg A/R S.S. rod Batch: <u>B134102</u>	0.00							
107									
Large Fab	Memo	0.52							
Large Fab	1- weld bushing as per dwg D3916 2- grind welds flush								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.03							
Quality Control									
120	QC10- Inspect visual per OSI004- ground welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

6x CC 16-8-9

6x DAS 43 9-89 AUG 10 2016

6x DAS 43 9-89 AUG 10 2016

1000

1000

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Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 6/16/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/21/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>wwt cy</i>	0.00							
130									
Packaging	Memo	0.02							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.17							
Quality Control									

6x *DAS 43 9-89* *AUG 10 2016*

16/8/11 *LD*

2m 16/08/10

Picklist Print

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Page 1

Work Order ID: 146401

146401

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 6/16/2016

Required Date: 6/21/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	79.0000	7	70			
D3759-1									**			CC 16-8-8	
Bushing													

Location

Loc Qty

Loc Code

WA004

79

143615

36

147322

43

100

f

723.8340

4.166

43.85263

44

CP

16-08-03

Location

Loc Qty

Loc Code

WA004

723.834

M134506

10

M134526

45.834

M134680

80

M134940

388

M135226

200

44

M304TS0.750W.049

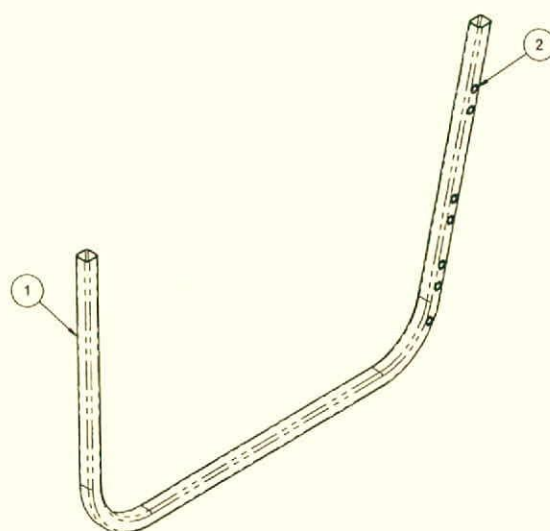
Purchased

No

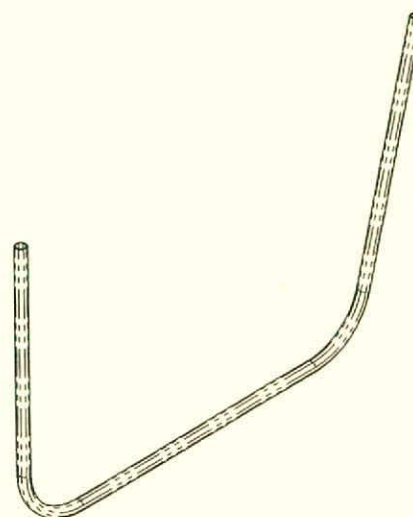
M304TS0 750W 049

304 SQ Tube .75x.75x.049W

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



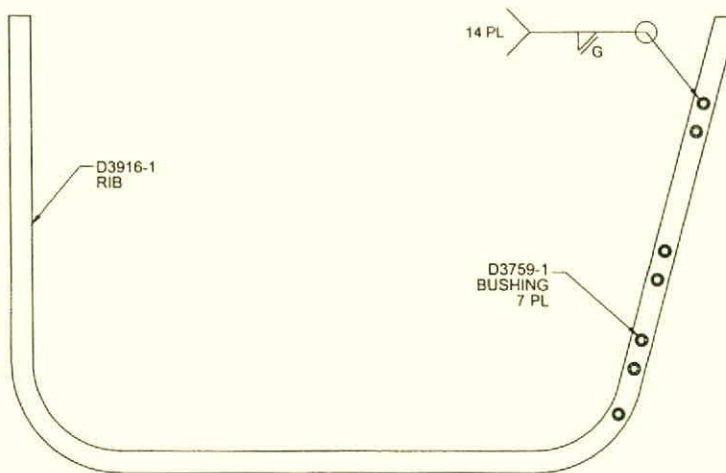
D3916-5 LIGHT RIB

146 401 MLS
16-05-18

OK 10.12.21
UNDER REVIEW
[10.10.18]
ADDITION OF HOLES BUSHING
ON D3916-041-1 RIBS.

RELEASED
2010-03-12
JMP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D3916	SHEET 1 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



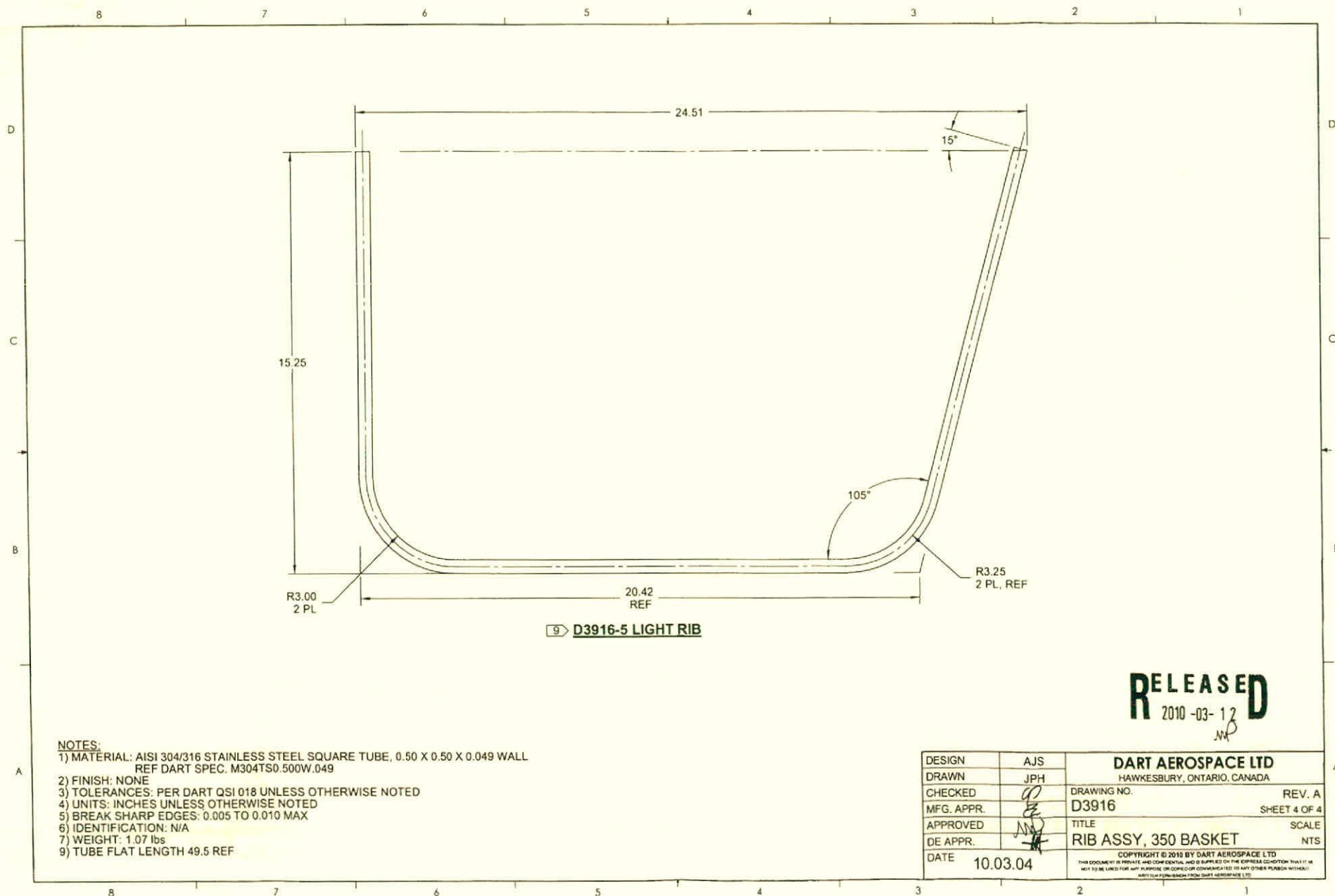
D3916-041 RIB ASSY

RELEASED
2010-03-12
NTP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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RELEASED
2010-03-12
JNP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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